

Date: Friday, 11/16/2007 7:21:21 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 35813	
Estimate Number : 13052	
P.O. Number : <u>N/A</u>	Part Number : D36704200
This Issue : 11/16/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3670 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u>	Drawing Revision : A
Previous Run : 35341	Material : <u>N/A</u>
	Due Date : 11/30/2007
Written By : <u>[Signature]</u>	Qty: 60 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: new issue 07-10-30 DD verified by:	
Est Rev:B Ecn 1056 Rev A dwg DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T03125W058	ALUM. SEAMLESS TUBE
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Comment: Qty.: 0.0207 f(s)/Unit Total : 1.8396 f(s)

Material:

(M6061T6T0.313W.058)

Batch: 106 347

20 07/11/07

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA711& DWG D3670

FOLIO REV: A

DWG REV: A

2-DEBURR AS REQUIRED

20 07/11/29

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/11/27

(73)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. 07/11/28

(73)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

BE 07/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/11/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:21:21 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 35813

Part Number: D36704200

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



73

Comment: FINAL INSPECTION/W/O RELEASE

D 07/11/28

Job Completion



u 07/16/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

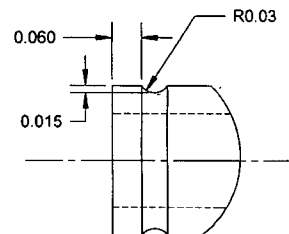
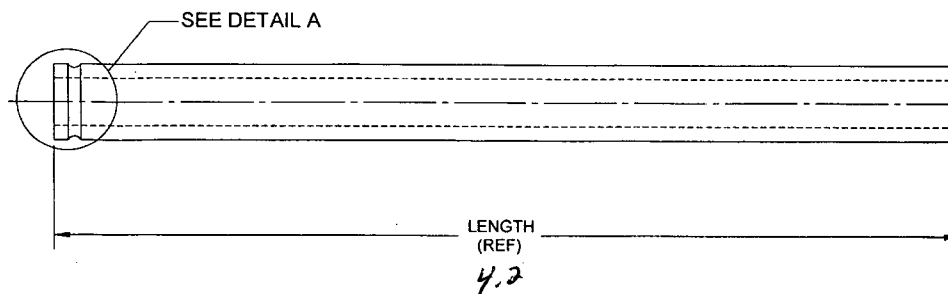
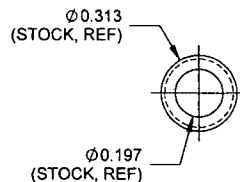
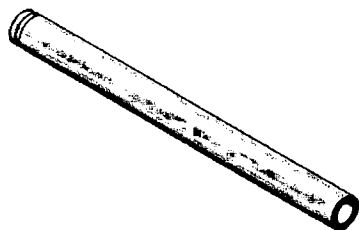
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



DETAIL A
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER
LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

RELEASED
07.11.06

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
30813

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
A	NEW ISSUE		DC	07.10.19
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3670 TITLE SPACER		REV. A
DRAWN	DC			SHEET 1 OF 1
CHECKED	h			SCALE 2:1
MFG. APPR.	h			
APPROVED	h			
DE APPR.	h			
DATE	07.10.19			

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☒ First Article ☐ Prototype

Measured by: <i>RP</i>	Audited by: <i>J.F.</i>	Prototype Approval:
Date: <i>07/11/22</i>	Date: <i>07/11/28</i>	Date:

